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D3207-1

Job Sheet 182229



Part No: D3207-1

Job Qty: 10 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/21/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEETS 1,2 IPP A 04.04.15 New issue KJ/RF IPP Rev:B Now On Waterjet 08-01-02 JLM
Verified By:DD IPP REV C AS PER REV B 12-03-23 JLM VERIFIED BY:EC IPP REV:D 12.05.10 per dwg
rev.c DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Waterjet		OK 18/08/22
100	Waterjet	10 pcs	8/31/18	8/31/18	0.00	2.30	Waterjet1		OK 18/08/22
110	QC	10 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Waterjet-1		OK 18/09/22 DAS
120	QC	10 pcs	8/31/18	8/31/18	0.00	0.00	QC8-2		AUG 27 2018 68
130	Brake NC	10 pcs	8/31/18	8/31/18	0.00	0.01	Brake NC 1		SB 9-89
140	QC	10 pcs	8/31/18	8/31/18	0.00	0.00	QC5		
150	HandFinish	10 pcs	8/31/18	8/31/18	0.00	0.53	HandFinish1		DR 18/10/10
155	QC	10 pcs	8/31/18	8/31/18	0.00	0.00	QC7-2		OK 18-10-10
160	Powdercoat	10 pcs	8/31/18	8/31/18	0.00	0.95	Powdercoat3		OK 18-10-10 DAS
170	QC	10 pcs	8/31/18	8/31/18	0.00	0.00	QC3		68
180	Packaging	10 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-1		OCT 11 2018 9-89
190	QC21-SA	10 Ea	8/31/18	8/31/18	0.00	0.00	QC21		OCT 11 2018 9-89

Part Op 100 - 1-Cut as per Dwg D3207 Dwg Rev: C Prog Rev: C 2-Debur if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Form as per dwg

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

155 - QC7-Inspect Chemical Conversion Coat

160 - Grey Sandtex(Ref 4.3.5.6) per QSI005 4.3 START TIME: 1:55 OVEN TEMPERATURE: 320°

FINISH TIME: 2:05

170 - QC3- Inspect Part Finish

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	1.4300 sf (.143 ea)	90-Start up Operation	228897 Solele321w

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.063	1	163	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval					
Description Work Order		Disposition							
		Completed By							
		Lead hand / Supervisor Approval Verification							
		QC / QA Coordinator Approval							
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-v ☐ Opera' ☐ Offse ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-v ☐ Opera' ☐ Offse ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%;"> Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Insu. ☐ Drill Holes ☐ </td> </tr> </table>				Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Insu. ☐ Drill Holes ☐
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Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Insu. ☐ Drill Holes ☐								
OTHER : _____									

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

